



Dart Aerospace Ltd.
1270 Aberdeen St
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Tel (613) 632-5200
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Rush!!!



D5374-3

Job Sheet 181910

Part No: D5374-3

Job Qty: 40 ea

Part Name: Bushing



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/13/18

Job Tracking No:

Due Date: 9/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 15-12-10 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea		9/28/18	0.00	0.00	Start Up Machining-4		18/10/06 JBD
100	Hardinge	40 pcs		9/28/18	0.00	8.00	Hardinge		
120	QC	40 pcs		9/28/18	0.00	0.00	QC8		
130	Packaging	40 pcs		9/28/18	0.00	0.00	Packaging3-2		2018-10-07
140	QC21-SA	40 Ea		9/28/18	0.00	0.00	QC21		OCT 19 2018

Part Op Descriptions: 100 - 1-TURN AS PER FOLIO FB445 & DWG D5374

OCT 19 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M303R0.500	303 Round Bar 0.500"	7.3200 ft (.183 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M303R0.500	7	48	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bushing	0.500Inches	+ 0.006 - 0.001	0.506 0.499	Diameter
2	Bushing	0.313Inches	+ 0.000 - 0.003	0.313 0.310	Diameter
3	Bushing	30.000Degrees	± 0.500	30.500 29.500	Angle
4	Bushing	0.035Inches	+ 0.030 - 0.010	0.065 0.025	
5	Bushing	2.050Inches	+ 0.000 - 0.005	2.050 2.045	
6	Bushing	0.020Inches	± 0.030	0.050 (0.010)	Radius
7	Bushing	0.050Inches	+ 0.000 - 0.005	0.050 0.045	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																												
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8	Bushing	0.196Inches $\pm$ 0.005	0.201 0.191	Diameter
9	Bushing	0.226Inches $\begin{matrix} + 0.010 \\ - 1.000 \end{matrix}$	0.236 (0.774)	
10	Bushing	90.000Degrees $\pm$ 0.500	90.500 89.500	Angle

Plex 8/13/18 1:12 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		1270 Aberdeen Street Hewitsonbury, ON K84 1K7 CANADA TEL.: 1 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 10/09/18 Container No: S116453 Part: D5374-3 Job No: 181910 Serial No/Batch: S116453 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's					
Description Work Order									
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
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